

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : _____							

Work Order ID 155050***155050***

Page 2

Friday, January 06, 2017 1:47:23 PM

Item ID: D206-559-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: 206L Series / 407 Bearpaws

Start Date: 1/12/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/24/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

0.00

180

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPPD206-559-013

LOCATION: FG013

190

0.00

190

QC

QC21- Final Inspection - Work Order Release

Memo

0.07

Quality Control

4 **DAS**
27
2-89**MAY 15 2017****DAS**
21
9-89**MAY 15 2017****DAS**
21
9-89**MAY 15 2017**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Root Cause		FAULT CATEGORY																																																													
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
OTHER : _____																																																															

Picklist Print

Friday, January 06, 2017 1:47:26 PM

Page 1

Work Order ID: 155050

155050

Parent Item: D206-559-013

D206-559-013

Parent Item Name: 206L Series / 407 Bearpaws

Start Date: 1/12/2017

Required Date: 1/24/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:J04.02.17Blank size changedKJ/JLM
IPP Rev:K 07-01-02 Was K10008 JLM
IPP Rev:L 08-01-09 Added Step 2 JLM Verified By:EC
IPP Rev:M 08-04-29 update seq. 8 and 12 DD verified by:EC
IPP Rev:N 08-10-15 New Manufacturing Method JLM Verified
By:EC IPP Rev G 10.10.04 per DSI9527 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-17A		Purchased	No			160	Each	222.0000	12	48			

AN4-17A

Bolt

**

MAY 11 2017

DAS 28
9-89

Location	Loc Qty	Loc Code
over003	150	
M136148	100	
M136406	50	
ST343	72	
M135966	72	

136983

DAS
27
9-89

AN4-20A

Purchased

No

160

Each

90.0000

12

48

AN4-20A

Bolt

**

MAY 11 2017

DAS 28
9-89

Location	Loc Qty	Loc Code
GA	6	
m116419	6	
ST343	84	
m135966	36	
m136148	48	

136586

DAS
27
9-89

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 2

Work Order ID: 155050

155050

Parent Item: D206-559-013

D206-559-013

Parent Item Name: 206L Series / 407 Bearpaws

Start Date: 1/12/2017

Required Date: 1/24/2017

Start Qty: 4.00

Required Qty: 4.00

D2182B Manufactured No

160 f

142.7650 2.5 10

D2182B

Rubber Cushion - Black (\$Per Foot)

**

MAY 11 2017

158886x15
144001x4

152571x1
130422x4

Location

Loc Qty

Loc Code

ST411

142.765

135093

142.765

(D2182B050) cut qty (6) at 5.00" as per dwg ***per kit***

D2274 Manufactured No

160 Each

655.0000 12 48

D2274

Radius Block

**

MAY 11 2017

Location

Loc Qty

Loc Code

FG

12

86855

12

ST006

340

150353

1

151763

339

ST012a

303

152449

303

D2432 Manufactured No

160 Each

2.0000 2 8

D2432

Bearpaw 19" X 24"

**

MAY 11 2017

Location

Loc Qty

Loc Code

ST430A

2

147544

1

150373

1

DAS
27
9-89

159102x7
155067x4

DAS
28
9-89

DAS
28
9-89

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 3

Work Order ID: 155050

155050

Parent Item: D206-559-013

D206-559-013

Parent Item Name: 206L Series / 407 Bearpaws

Start Date: 1/12/2017

Required Date: 1/24/2017

Start Qty: 4.00

Required Qty: 4.00

D2438 Manufactured No 160 Each 51.0000 6 24

D2438

Clamp

**

13050x4
147538x2 MAY 11 2017

DAS
6
9-89 28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST542

51

151376 x2

27

152451

24

39440x18
128921x4

D2529

Manufactured No 160 Each 335.0000 12 48

D2529

Washer

**

MAY 11 2017

DAS
6
9-89 28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST008

335

150080

135

153945

100

154187

100

155083

D2732

Manufactured No 160 f 348.2457 2.5 10

D2732

Rubber Cushion (\$per foot)

**

12506x12 MAY 11 2017

DAS
6
9-89 28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST412

348.2457375

117118

5E-10

143793

5.6531E-05

150042

348.245681

136785x7

150002x8

(D2732-050) cut qty (6) at 5.00" as per dwg ***per kit***

Picklist Print

Friday, January 06, 2017 1:47:26 PM

Page 4

Work Order ID: 155050

155050

Parent Item: D206-559-013

D206-559-013

Parent Item Name: 206L Series / 407 Bearpaws

Start Date: 1/12/2017

Required Date: 1/24/2017

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

160

Each

2,566.000

12

48

MS21042L4

Nut

MAY 11 2017

DAS
6
28
9-80

Location

Loc Qty

Loc Code

FP001

18

m133363

18

GA

192

m135058

192

OVER007

1000

m136182

500

m136450

500

ST303

1356

m135864

24

m135979

332

m136295

1000

137321

DAS
27
9-80

NAS1149D0463J

Purchased

No

160

Each

3,549.000

24

96

NAS1149D0463J

Washer

MAY 11 2017

DAS
6
28
9-80

Location

Loc Qty

Loc Code

GA

80

M134508

13

M135056

67

ST260a

2200

M136192

600

M136263

600

M136406

1000

ST263

1269

M136044

1269

137381

DAS
7
39

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date: _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			16	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP

Work Order ID 155050***155050***

Friday, January 06, 2017 1:47:23 PM

Item ID: D206-559-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop ***NS2***

Item Name: 206L Series / 407 Bearpaws

Start Date: 1/12/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/24/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan:

Date: JAN 06 2017 Tooling:

Date:

Stop

NR2

QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D206-559

rev L

MAY 04 2017

0.00

100

Document Control

DOCUMENT CONTROL

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D206-559-013 CHG006

MAY 04 2017

160

Pick Kit

0.00

160

Packaging

Memo

0.00

Packaging

170

QC4- 100% Inspect kits for completeness

0.00

170

QC

Memo

0.02

Quality Control



Supplemental Type Certificate

This approval is issued to:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario
K6A 1K7

Number: SH92-17

Issue No.: 7

Approval Date: June 19, 1992

Issue Date: October 26, 2001

Responsible Region: Ontario

Aircraft/Engine Type or Model: Bell 206 A, B, L, L-1, L-3, L-4, 407

Canadian Type Certificate or Equivalent: H-92

Description of Type Design Change: Utility Equipment Kit

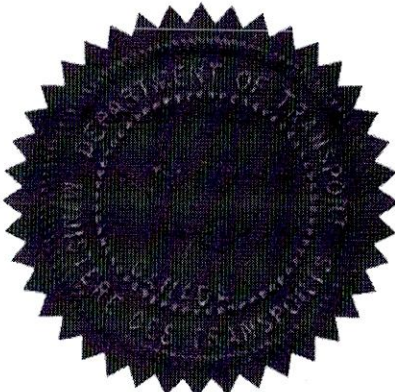
**Installation/Operating Data,
Required Equipment and Limitations:**

The Utility Equipment Installations, consisting of Cargo Mirror, Bear Paw and Preflight Sure-Grip Steps, are to be carried out in accordance with Dart Master Document List drawing no. D206-582, Rev. H, dated 01.10.01, or later Transport Canada approved revision.

Approved Combinations: These installations may be used in any combination provided the aircraft effectivity restrictions of the individual kits, as defined on the Dart Master Document List, are followed.

Required Equipment:

1. Flight Manual Supplement No. FMS-D206-582, Rev. C, dated 01.10.03, or later Transport Canada approved revision (for mirror installation)
2. Maintenance in accordance with the following ICA's (as required by combination installed):
ICA-D206-558, Rev. 0, dated 01.09.20 (Mirror),
ICA-D206-559, Rev. 0, dated 01.09.10 (Bear Paw),
ICA-D206-581, Rev. 0, dated 01.09.26 (Steps), or later Transport Canada accepted revisions.



Conditions: This approval is only applicable to the type/model of aeronautical product specified therein. Prior to incorporating this modification, the installer shall establish that the interrelationship between this change and any other modification(s) incorporated will not adversely affect the airworthiness of the modified product.

Alex Pompei
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For Minister of Transport

Canada